

Work Order ID 58062

April 22, 2010 1:07:01 PM



Page 1

Item ID: DSI 9515-011

Accept



Setup Start



Revision ID:

Item Name: Lug Upgrade

Stop



Start Date: 4/22/10 Start Qty: 1.00

Required Date: 4/22/10 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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DSI 9515	A
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100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP DSI9515-011 CHG001

PS 10-4-27
①

110

0.00



Pick Kit

Packaging

Memo

0.00

7m, 1 w/04/23

10-4-27
②

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

5/10/10/23

③

Quality Control

Work Order ID 58062



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Item ID: DSI 9515-011

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Setup Start



Revision ID:

Stop



Item Name: Lug Upgrade

Start Date: 4/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/22/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI9515-011

Location: _____

PNP 57243

Handwritten signature

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/27

mf

10-4-26

Picklist Print

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Page 1

Work Order ID: 58062

Parent Item: DSI 9515-011

Parent Item Name: Lug Upgrade

Comments: IPP Rev:A new issue DD 10.04.21 verified by:EC

Start Date: 4/22/10

Required Date: 4/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D4091-1 Mounting Lug		Manufactured	No			110	Each	0.0000	4.0000			
D3910-3 Crosstube Lug		Manufactured	No			110	Each	12.0000	4.0000			

B57250

4x m-h 10/04/23

Warehouse
Location

Main Warehouse

st507

57108 ✓

Loc Qty

12

12

Loc Code

4x m-h 10/04/23

D3984 Rubber Extrusion, Crosstube		Manufactured	No			110	f	491.8950	8.0000			
--------------------------------------	--	--------------	----	--	--	-----	---	----------	--------	--	--	--

Warehouse
Location

Main Warehouse

ST408

53707 ✓

Loc Qty

491.895

491.895

Loc Code

8x m-h 10/04/23

AN4-14A Bolt		Purchased	No			110	Each	129.0000	16.0000			
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Warehouse
Location

Main Warehouse

ST358

113359 ✓

Loc Qty

129

129

Loc Code

16x m-h 10/04/23

Picklist Print

April 22, 2010 1:07:00 PM

Work Order ID: 58062



Parent Item: DSI 9515-011



Parent Item Name: Lug Upgrade

Start Date: 4/22/10

Required Date: 4/22/10

Comments: IPP Rev:A new issue DD 10.04.21 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149D0432J	416 327	Purchased	No			110	Each	100.0000	16.0000			



Washer NAS1149 DU 4630

Warehouse Loc Qty Loc Code
Location

Main Warehouse M113 706
ST298 100
11735 100

416
16X m-h 10/04/23

MS21042L4 Purchased No 110 Each 1,400.000 8.0600



Nut

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST139 2
111827 2
Main Warehouse
ST300 898
113422 112
114108 778
9063 8
Main Warehouse
ST463 500
114416 500

78
8X m-h 10/04/23

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-602 REV E (OR EARLIER REV.)
AND INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D350-602 REV. 0

REF. TCCA STC: SH93-97

REF. FAA STC: SR01144NY

REF. EASA STC: EASA.IM.R.S.01290

PURPOSE

Dart Heli-Utility-Pods D350-602-011 @ CHG 006 and D350-602-013/-014 @ CHG 002 have new attachment lugs.

CHANGE

The D2230-1/-3 clamps are replaced with wider D4091-1/D3910-3 lugs. The abrasion strip is replaced with D3984-030 rubber extrusion. The D2462-1700 Neoprene Seal is replaced with D2461-1700 Neoprene 'D' Seal. The modified parts list for Installation Instruction D350-602 and Instructions for Continued Airworthiness ICA-D350-602 is shown on sheet 2 of this service instruction. Install the lugs as shown in Figure 1 & 2 of this service instruction. The pod should otherwise be installed per D350-602 and maintained per ICA-D350-602.

The weight and balance for Dart Heli-Utility-Pods D350-602-011 @ CHG 006 and D350-602-013/-014 @ CHG 002 (or later) are updated as follows:

5.0 WEIGHT AND BALANCE (D350-602 Rev. E)

25.6 WEIGHT AND BALANCE (ICA-D350-602 Rev. 0)

The following weight and balance information is for the Dart **Heli-Utility-Pod™**. The weight and balance of any parts that are removed from the aircraft to perform this installation or equipment installed/stowed in the pods are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-602-011 @ CHG 006	61.2 lb	±51.0 in	±3121 in-lb	135 in	8262 in-lb
Heli-Utility-Pod™ LH or RH	27.8 kg	±1.29 m	±35.9 m-kG	3.43 m	95.4 m-kG
D350-602-013 @ CHG 002	61.2 lb	-51.0 in	-3121 in-lb	135 in	6872 in-lb
Heli-Utility-Pod™ LH	27.8 kg	-1.29 m	-35.9 m-kG	3.43 m	79.2 m-kG
D350-602-014 @ CHG 002	61.2 lb	+51.0 in	+3121 in-lb	135 in	6872 in-lb
Heli-Utility-Pod™ RH	27.8 kg	+1.29 m	+35.9 m-kG	3.43 m	79.2 m-kG

LUG UPGRADE KIT






The Dart DSI-9515-011 kit is available to upgrade D350-602-XXX Heli-Utility-Pods made to earlier change numbers with D4091-1 / D3910-3 lugs. The lugs should be installed per Figure 1 & 2 of this service instruction.

QTY	Part Number	Description
-011		
X	DSI-9515-011	LUG UPGRADE KIT
4	D4091-1	LUG
4	D3910-3	LUG
8	D3984-030	RUBBER EXTRUSION
16	AN4-14A	BOLT
32	AN960JD416	WASHER (OR NAS1149DO463J)
16	MS21042L4	NUT (OR MS21042-4)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 10.04.23
CERT. NO.: SH93-97
ISSUE NO.: 4

B	NAS1149DO463J WAS xDN432J & CHG QTY	CP	10.04.23
A	NEW ISSUE	CP	10.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV.
MFG. APPR.	N/A	DSI 9515	SHEET 1 OF
APPROVED		TITLE	SCAL
DE APPR.		LUG MODIFICATION	N
DATE	10.04.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	